

47

DART AEROSPACE LTD		Work Order:	19537
Description: Long Step Assembly – High Skid, LH D350-591-211		Part Number:	704A 41 640 008
Dwg: D3070 Rev. A1 RF 02.11.13		Qty:	10
		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HA	03.08.27	10
2	DC	Photocopy bluefile and type labels per PPP 704A 41 640 008 CHG001 CHG002 WK 45 HA	HA	04.03.12	10
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3070 using cutting table setup DT 8185-2A Pick: Qty Part Number Description Batch 1 D2622-120C Extrusion B 18809	ml	04-03-08	10
4	GA	Drill extrusion per Dwg D3070 using Jig DT8680 for rivets.	ml	04-03-08	10
5	GA	Deburr	ml	04-03-08	10
6	QC5	Inspect work to Step 5	HA	04/03/08	10
7	WA	Bevel end for welding FWD ONLY	HA	04/03/08	10
8	WA	Weld Support using Jig DT8681, weld Fwd End Plate per QSI 004 & Dwg D3070 Pick: Qty Part Number Description Batch 1 D3063-1 Support B19830/B19555 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066	HA	04/03/08	10
9	GA	Grind End Plate flush	ml	04-03-12	10
10	QC9 & 5	Inspect weld and work to Step 9	HA	04/03/17	10
11	FP	Chemical conversion coat as per QSI 005 4.1	PD	01-03-19	10
12	GA	Assemble Leg Assembly as per Dwg D3070. D3066-1 are done with Step Leg Assy, don't add to the BOM. RF 03.01.10 Pick: Qty Part Number Description Batch 1 D3065-041 Step Leg Assy B19557 2 D3066-1 Spacer B19557 16 MS20600AD4W4 Rivet M13767	ml	04-03-22	10
13	QC5	Inspect work to step 12	HA	04-03-22	10
14	WA	Bevel Aft end for welding	HA	04/03/22	10
15	WA	Inspect for foreign object per QSI 024	HA	04/03/22	10
16	WA	Weld Aft End Plate per QSI 004 & Dwg D3070 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13672	HA	04/03/22	10

BB 04-03-23-2B

CANCEL RF 03.01.10

UNDER REVIEW

03-06-06 RF

See David

RELEASED
02/11/01 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

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Page 2 of 2		

17	GA	Grind End Plate flush	SB	04/03/23	10																																																				
18	QC9 & 5	Inspect work to Step 17 – Check dimension 110.56" from Dwg D3070 110.71" RF 02.11.13	SB	04.03.23	10																																																				
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	SB	04.03.24	10																																																				
20	FP	Wing Walk per Dwg D3070 and QSI 005 4.4	SB	04.03.24	10																																																				
21	QC3	Inspect Powder Coat and Wing Walk	SB	04.03.24	10																																																				
22	KP	Pick: Packing Kit <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B035</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B20207</td></tr><tr><td>2</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B19645</td></tr><tr><td>2</td><td>D3064-1</td><td>Clamp</td><td>B20470</td></tr><tr><td>1</td><td>D3079-041</td><td>Support Assy</td><td>B20456</td></tr><tr><td>4</td><td>D3080-1</td><td>Clamp</td><td>B19559</td></tr><tr><td>2</td><td>AN3-35A</td><td>Bolt</td><td>M13063</td></tr><tr><td>10</td><td>AN4-11A</td><td>Bolt</td><td>M13735</td></tr><tr><td>4</td><td>AN960JD10</td><td>Washer</td><td>M13441</td></tr><tr><td>20</td><td>AN960JD416</td><td>Washer</td><td>M13356</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M13536</td></tr><tr><td>10</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B035	Rubber Cushion	B20434	8	D2274	Radius Block	B20207	2	D2856-400-720	Abrasion Strip	B19645	2	D3064-1	Clamp	B20470	1	D3079-041	Support Assy	B20456	4	D3080-1	Clamp	B19559	2	AN3-35A	Bolt	M13063	10	AN4-11A	Bolt	M13735	4	AN960JD10	Washer	M13441	20	AN960JD416	Washer	M13356	2	MS21042L3	Nut (or -3)	M13536	10	MS21042L4	Nut (or -4)	M13276	CP	04/03/04	10
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23	QC4	Inspect 100% Kit for Completeness on the W/O	SB	04.03.25	10																																																				
24	PK	Package for shipping as per PPP 704A 41 640 008 Rev A	CP	04.03.25	10																																																				
25	AC	Cost / part 224.91	SB	04.03.29	10																																																				
26	DC	Close W/O 224.91 Inspect Level 21	SB	04.03.26	10																																																				

Rev	Date	Change	Revised By	Approved
A	02.11.01	New issue	KJ RF	SB
A1	03.01.14	110.71" WAS 110.56"; Dwg Rev A1	SB	SB
A2	03.07.16	D3194-041 WAS D3079-041; CHG002	SB	SB

UNDER REVIEW

03.06.06 RF

See David

CANCEL RF 03.07.16

RELEASED

02/11/01 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
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QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 27, 2003
02:05 pm

Work Order No : 0019537
Project Name : *704A 41 640 008
Project For : WK347
Work Order Type : Main
Main WO Number :
House Part Number : *704A 41 640 008
Description : Heli-Access-Step,Long LH
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 08-27-03
Est Finish Date : 11-28-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00